

Work Order ID 128079

Tuesday, January 06, 2015 9:24:58 AM

128079

Page 1

Item ID: D350-636-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Skidtube LH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Stop ***NS2***

Start Date: 1/6/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/6/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 15-01-06 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Rate Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750-041	G								

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

record fwd angle: 89.7°

FEB 11 2015

Photocopy blue file and type labels per PPP D350-636-011 CHG 007

15-1-7 *JK*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

Item ID: D350-636-011

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Skidtube LH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Stop ***NS2***Start Date: 1/6/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/6/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Down Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110									
Skidtubes									
Skidtubes									
	Memo	0.00							
	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side.								
	ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE								
	Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for 2nd side only DT8863B for first side (detail B)								
	4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE.								
	5- Drill only two fwd step holes using DT9616. Ensure proper positioning.								
	6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".								
	7- Open up holes of Detail A to 0.297" (total of 2 holes per side)								
	8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004								

DGC 15-1-7.

DGC 15-1-7.

15-1-7

BE 15-01-08

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 3

Item ID: D350-636-011**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Item Name:** Skidtube LH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible**Stop *NS2*****Start Date:** 1/6/2015 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 1/6/2015 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Description****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**A/R Aluminum Rod batch: *ML300812*

9-Grind welds flush as per Dwg D2750

7 BE1501-08

120

120

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

DAS
38
9-89

JAN 08 2015

130

130

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

DAS
38
9-89

JAN 08 2015

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Page 4

Item ID: D350-636-011

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Skidtube LH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Stop ***NS2***Start Date: 1/6/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/6/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

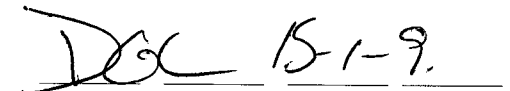
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00							
Quality Control									



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Item ID: D350-636-011

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Item Name: Skidtube LH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Stop ***NS2***Start Date: 1/6/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/6/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Down Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
160									
Skidtubes									
Skidtubes	Memo 1-Open up holes using hole saw of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 2-Open up holes using hole saw of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750. 3- Open float hole using un-bit to 0.500" (4 per side) 4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8) 5-Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: <u>131120</u> exp. date: <u>15-10-21</u> 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: <u>M130812</u> 9- At section AJ-AJ drill out x-bolt spacer to 0.404" 10-Grind welds flush as per Dwg D2750	0.00							

15-1-9

BE15-01-12

15-1-13

Work Order ID 128079

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Page 6

Item ID: D350-636-011 Accept *N900040100* Setup Start *NS1*

Revision ID:

Item Name: Skidtube LH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Stop *NS2*

Start Date: 1/6/2015 Start Qty: 1.00 *1*

Required Date: 1/6/2015 Req'd Qty: 1.00 *1*

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*

QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Base Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750								
	12-Deburr holes, ensure tube is free of all scratches before sending to paint.								
170	QC10- Inspect visual per QS1004- ground welds	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control	***VERIFY C'BOARD IS GOOD***								

15-1-13

15-01-19

15-01-19

DAS
9
9-89

DAS
9
9-89

Work Order ID 128079

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Page 8

Item ID: D350-636-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube LH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float
 Start Date: 1/6/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/6/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230 *230*	HandFinishing	0.00							
HandFinish	Memo	0.00							
Hand Finishing	1- Install inserts as per Dwg D2750								
	2-Inspect for Foreign Objects								
	3- Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>M131120</u> EXP DATE: <u>5/10/15</u>								
	4- Assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>M129305</u> RTU 5981361K 11125792 exp 15/06								
	5- Coat all exposed fasteners with "LPS Procyon" batch: <u>M122900</u>								
240	QC5- Inspect part completeness to step on W/O	0.00							
240	Memo	0.00							
QC									
Quality Control									

DAS
38
9-88

FEB 05 2015

Work Order ID 128079

Tuesday, January 06, 2015 9:24:58 AM

128079

Page 9

Item ID: D350-636-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube LH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float
 Start Date: 1/6/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/6/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00							
Quality Control	*****ensure antiseize is on AN8C21A bolts*****								
270	Packaging	0.00							
270									
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-011								

FEB 10 2015

FEB 11 2015

FEB 12 2015

DAS
27
9-89

DAS
46
9-89
FEB 11 2015

DAS
06
9-89

DAS
46
9-89

OK

Work Order ID 128079

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Item ID: D350-636-011**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Item Name:** Skidtube LH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible**Stop *NS2*****Start Date:** 1/6/2015 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 1/6/2015 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

ML5 15-02-12
MF
15-2-12

Picklist Print

Tuesday, January 06, 2015 9:25:02 AM

Page 1

Work Order ID: 128079

128079

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-23 As per Rev D JLM
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC
 IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec
 IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010
 DD verf:EC IPP Rev:P 10.06.22 revise
 seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH
 DD verf:EC IPP REV:R 13.08.27 PER ECN13-594 DD
 VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3492-1 *D3492-1* Plug		Manufactured	No			230	Each	189.0000	8	8			
Location FP001 125904 Loc Qty 189 189 Loc Code													
D3492-3 *D3492-3* Plug		Manufactured	No			230	Each	210.0000	8	8			
Location FP001 125905 Loc Qty 210 210 Loc Code													
NAS1611-010 *NAS1611-010* O-RING		Purchased	No			230	Each	188.0000	8	8			
Location FP001 m130797 Loc Qty 188 188 Loc Code													

**

B129057 (x8) 11/15/02/01

**

11/15/02/01

**

11/15/02/01

M131329

x8

Picklist Print

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Page 2

Work Order ID: 128079

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Parent Item: D350-636-011

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Parent Item Name: Skidtube LH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

NAS1149D0863J

Purchased

No

250

Each

758.0000

Start Qty: 1.00

2

2

Required Qty: 1.00

NAS1149D0863.J

Washer

**

DAS
27
9-09

DAS
46
9-09

FEB 10 2015

DAS
26
9-09

Location

Loc Qty

Loc Code

FP001

57

125484

57

ST260a

700

125268

600

125635

100

st268

1

125268

1

D2744

Manufactured

No

110

Each

38.0000

1

1

D2744

Cap

**

BB15-01-08

Location

Loc Qty

Loc Code

LG001

38

125894

38

D2600-3-BENT-LH

Manufactured

No

110

Each

12.0000

1

1

D2600-3-BFNT-1 H

Extrusion Bent LH

**

DGC 15-1-7.

Location

Loc Qty

Loc Code

LG002

12

125886

12

D2743

Manufactured

No

160

Each

155.0000

8

8

D2743

Crossbolt Spacer

**

BB1501-12

Location

Loc Qty

Loc Code

LG001

155

125893

8

127636

147

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Shop Packet Print

Page 2

Picklist Print

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Work Order ID: 128079

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Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

D2739

Manufactured No

160 Each

Start Qty: 1.00
13.0000 1 1

Required Qty: 1.00

D2739

350 I Beam

**

15-1-9 *JK*

Location

Loc Qty

Loc Code

LG003

13

125889

13

D3490-3

Manufactured No

160 Each

107.0000 4 4

D3490-3

Cross Bolt Spacer

**

BB 15-01-12

Location

Loc Qty

Loc Code

LG001

107

125903

107

D3490-1

Manufactured No

160 Each

117.0000 4 4

D3490-1

Cross Bolt Spacer

**

BB 15-01-12

Location

Loc Qty

Loc Code

LG001

117

125902

117

ALS4-1032-225

AEIS8-1032-225 Purchased

No

Each

1,622.000

38

ALS4-1032-225

Rivnut

**

el 15/02/01

Location

Loc Qty

Loc Code

FG

120

M127028

120

FP001

698

M131067

698

st549

804

M131067

804

X 38

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Shop Packet Print

Page 3

Picklist Print

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Page 4

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Parent Item: D350-636-011

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Parent Item Name: Skidtube LH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

D3793-3

Manufactured No

230

Each

40.0000

Start Qty: 1.00

Required Qty: 1.00

1 1

D3793-3

Wearplate Aft

**

ll 15/02/04

Location

Loc Qty

Loc Code

FP002

40

125915

40

AN8C35A

Purchased No

230

Each

27.0000

1

AN8C35A

Bolt

**

ll 15/02/04

Location

Loc Qty

Loc Code

FG

5

121275

5

1131367

FP001

22

m130114

1

m130784

21

D3793-1

Manufactured No

230

Each

44.0000

1

D3793-1

Wearplate Fwd

**

ll 15/02/04

Location

Loc Qty

Loc Code

FP002

44

125914

43

126905

1

D3488-041

Manufactured No

230

Each

13.0000

1

D3488-041

Blade Fitting LH

**

ll 15/02/04

Location

Loc Qty

Loc Code

FP001

13

124200

1

125897

7

125898

5

13127229

ll

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Work Order ID: 128079

128079

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

D3794-3

Manufactured No

230 Each

75.0000 Start Qty: 1.00 1 1

Required Qty: 1.00

D3794-3

Gasket Aft

**

15/02/01

Location

Loc Qty

Loc Code

FP001

75

124948

1

125917

34

127383

39

92658

1

AN6C44A

Purchased No

230 Each

110.0000 4 4

AN6C44A

Bolt

**

15/02/01

Location

Loc Qty

Loc Code

FG

2

103964

2

FP001

4

m130863

4

ST286A

17

m130863

17

ST332

11

m130863

11

ST333

76

m131151

76

MS21083C8

Purchased No

230 Each

116.0000 1 1

MS21083C8

Nut

**

15/02/01

Location

Loc Qty

Loc Code

ST300

116

m131049

116

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Work Order ID: 128079

128079

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

D3536-25

Manufactured No

230 Each

38.0000 Start Qty: 1.00 1 1

Required Qty: 1.00

D3536-25

Gasket Center

**

ell 15/02/01

Location

Loc Qty

Loc Code

FG

6

87053

2

95328

4

FP001

32

125909

32

X

D3631-1

Manufactured No

230 Each

186.0000 8 8

D3631-1

Washer

**

ell 15/02/01

Location

Loc Qty

Loc Code

FP001

186

125912

186

13128320

X8

D3791-1

Manufactured No

230 Each

38.0000 1 1

D3791-1

Wearpad

**

ell 15/02/01

Location

Loc Qty

Loc Code

FP002

38

125913

38

X

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Picklist Print

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Page 7

Work Order ID: 128079

128079

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

NAS1149C0332R

Purchased

No

230

Each

Start Qty: 1.00
4,519.000 38 38

Required Qty: 1.00

NAS1149C0332R

WASHER

**

ll 15/02/01

Location

Loc Qty

Loc Code

FP001

2657

m130325

2657

GA

126

125654

126

ST271

1736

m130325

736

m130466

1000

x38

D2745

Manufactured

No

230

Each

92.0000 8 8

D2745

Bushing

**

ll 15/02/01

Location

Loc Qty

Loc Code

FP001

92

13123585

x2

125895

92

AN3C5A

Purchased

No

230

Each

1,165.000 34 34

AN3C5A

Bolt

**

ll 15/02/01

Location

Loc Qty

Loc Code

FG

5

122800

5

FP001

17

M130851

17

ST338a

1143

M130770

1000

M130851

143

x34

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Page 8

Work Order ID: 128079

128079

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

D3537-1

Manufactured No

230

Each

67.0000

Start Qty: 1.00

Required Qty: 1.00

3 3

D3537-1

Wearpad

**

ll 15102000

Location

Loc Qty

Loc Code

FG

18

B128225

x 3

79833

8

88562

10

FP001

49

125418

3

126306

46

NAS1149C0832R

Purchased No

230

Each

191.0000

1

1

NAS1149C0832R

Washer

**

ll 15102000

Location

Loc Qty

Loc Code

FP001

47

m114915

47

x 1

ST271

144

m125807

144

AN3C6A

Purchased No

230

Each

616.0000

4

4

AN3C6A

Bolt

**

ll 15102000

Location

Loc Qty

Loc Code

CA

39

m128704

39

FG

10

122416

10

FP001

126

m128769

126

ST338a

441

m128769

441

x 1

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Page 9

Work Order ID: 128079

128079

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

NAS1611-013

Purchased No

230 Each

Start Qty: 1.00
958.0000 8 8

Required Qty: 1.00

NAS1611-013

O-RING

**

ll 15/02/01

Location

Loc Qty

Loc Code

FP001

958

m130758

958

48

D3535-25

Manufactured No

230 Each

10.0000 1 1

D3535-25

Wearplate Center

**

ll 15/02/01

Location

Loc Qty

Loc Code

FG

2

95077

2

B127851

45

FP002

8

125908

8

D3794-1

Manufactured No

230 Each

36.0000 1 1

D3794-1

Gasket Fwd

**

ll 15/02/01

Location

Loc Qty

Loc Code

FP001

36

124438

1

125916

35

41

MS21043-6

Purchased No

230 Each

214.0000 4 4

MS21043-6

NUT

**

ll 15/02/01

Location

Loc Qty

Loc Code

FG

20

103693

20

FP001

194

m130325

6

m130726

188

84

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Page 10

Work Order ID: 128079

128079

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

D3493-1

Manufactured No

250

Each

Start Qty: 1.00
109.0000 2 2

Required Qty: 1.00

D3493-1

Washer

DAS
06
9-89

**

DAS
27
FEB 10 2015
DAS
46
9-89

Location

Loc Qty

Loc Code

FG

10

97201

10

ST046

99

125906

99

***ONLY INSTALL IF INSTALLING ON APICAL
FLOAT SYSTEM***

MS21083C8

Purchased No

250

Each

116.0000 2 2

MS21083C8

Nut

DAS
06
9-89

**

DAS
27
FEB 10 2015
DAS
46
9-89

Location

Loc Qty

Loc Code

ST300

116

m131049

116

AN8C21A

Purchased No

250

Each

20.0000 2 2

AN8C21A

Bolt

**

DAS
27
FEB 10 2015
DAS
46
9-89

Location

Loc Qty

Loc Code

FG

2

123966

2

ST332

18

m131100

18

DAS
06
9-89

MBD47

2

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Work Order ID: 128079

128079

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

NAS1515H3L

Purchased No

230 Each

Start Qty: 1.00
4 4

Required Qty: 1.00

***NAS1515H3I ***

Washer

**

Handwritten signature and date 1/5/2015

Location	Loc Qty	Loc Code
FG	40	
102472	40	
FP001	99	
m127831	99	
ST266	556	
m127831	56	
m130726	500	

Handwritten checkmark

D2741

Manufactured No

250 Each

11.0000 1 1

D2741

Replacement Blade

**

DAS
27
9-89

DAS
46
9-89

FEB 10 2015

Location	Loc Qty	Loc Code
FG	10	
100664	3	
113640	2	
115522	5	
ST538	1	
124047	1	

Handwritten B12S89p

Handwritten J

D3532-1

Manufactured No

250 Each

32.0000 2 2

D3532-1

Spacer

**

DAS
27
9-89

DAS
46
9-89

FEB 10 2015

Location	Loc Qty	Loc Code
ST048	32	
125907	32	

Handwritten 2

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QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1			D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
 STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
 OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
 MINIMUM YIELD TENSILE STRENGTH = 35 KSI
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
- FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

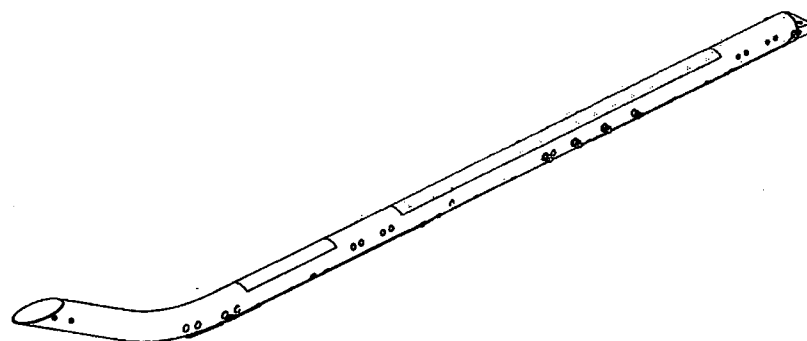
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128079 MLJ

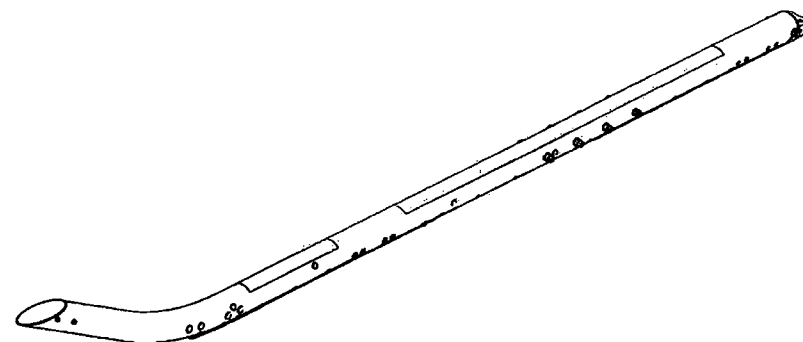
1501-06

RELEASED
2013-08-13

G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS: +0.010/-0.000, WAS: +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR15-276 AND NCR15-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-4 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL), WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	MM	KENT, WA	
CHECKED	MM	DRAWING NO.	REV. G
MFG. APPR.	MM	D2750	SHEET 1 OF 11
APPROVED	MM	TITLE	SCALE
DE APPR.	MM	350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 1996 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



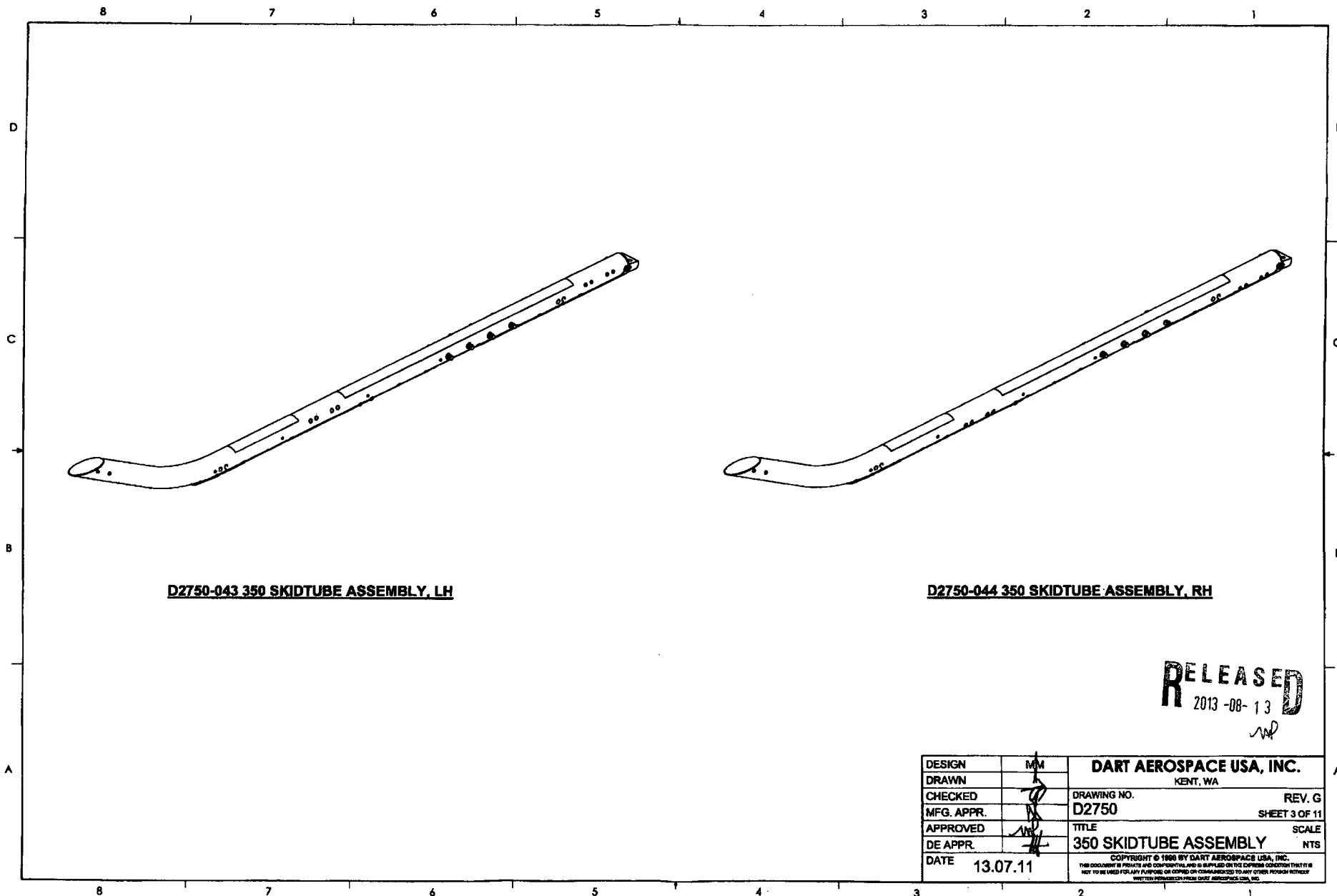
D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2013-08-13
NR

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	<i>[Signature]</i>	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D2750	REV. G
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 11	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS FOR THE USE OF THE USER AND IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT PERMISSION FROM DART AEROSPACE USA, INC.	

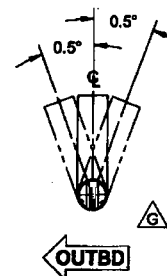
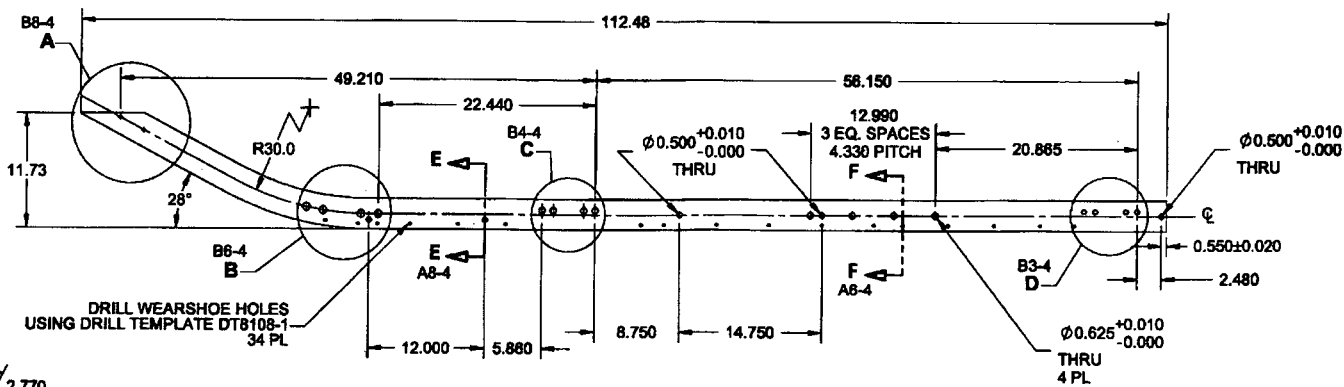


D2750-043 350 SKIDTUBE ASSEMBLY, LH

D2750-044 350 SKIDTUBE ASSEMBLY, RH

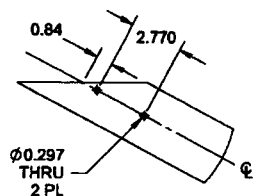
RELEASED
2013-08-13
nd

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 3 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 1990 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	

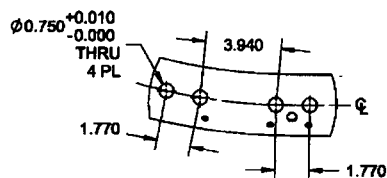


MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

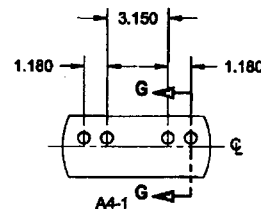
D2750-1 LH SKIDTUBE



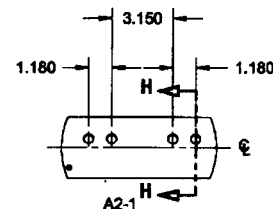
D7-4
DETAIL A
SCALE 2X



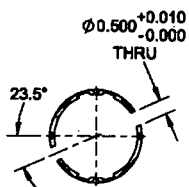
D7-4
DETAIL B
SCALE 2X



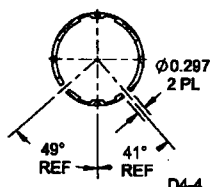
D5-4
DETAIL C
SCALE 2X



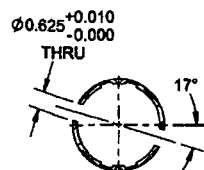
D3-4
DETAIL D
SCALE 2X



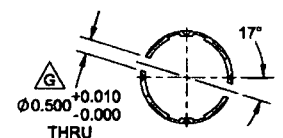
D6-4
SECTION E-E
SCALE 3X, 2 PL



D4-4
SECTION F-F
SCALE 3X, 17 PL



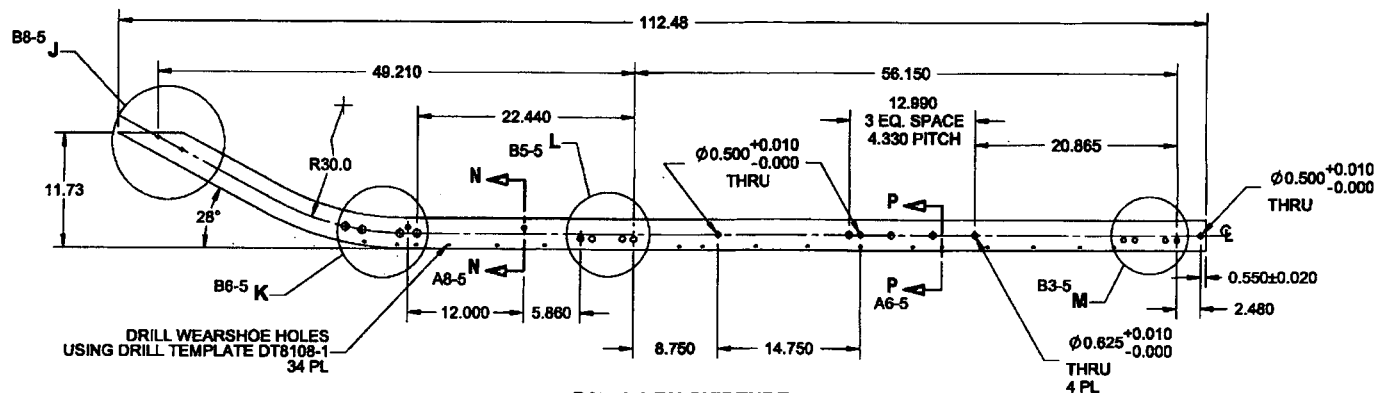
B4-4
SECTION G-G
SCALE 3X, 4 PL



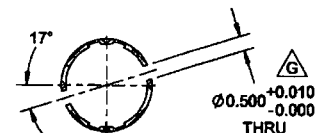
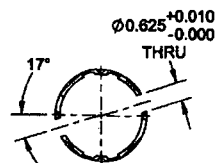
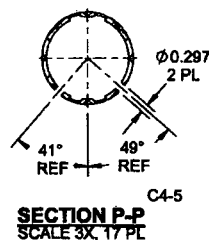
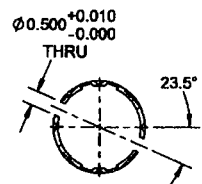
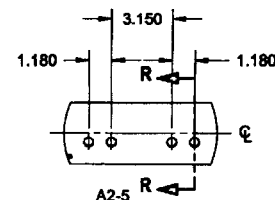
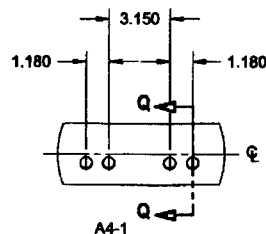
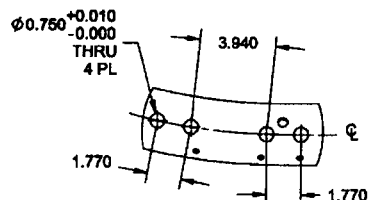
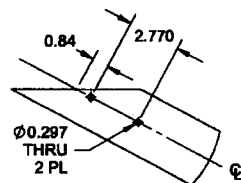
B2-4
SECTION H-H
SCALE 3X, 4 PL

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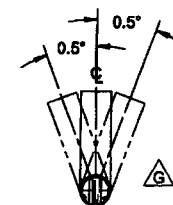
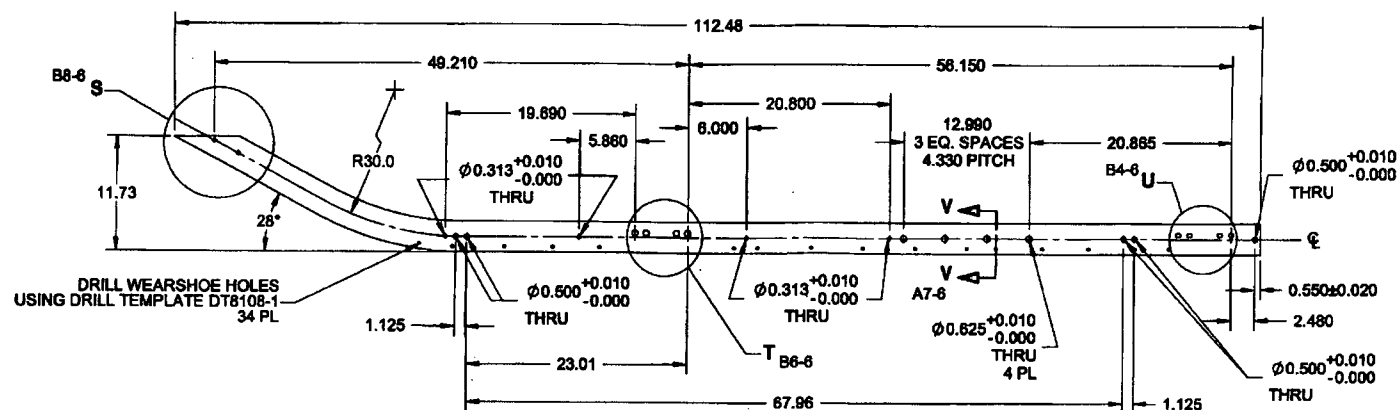
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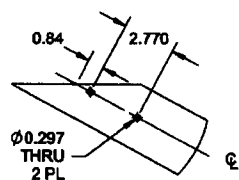
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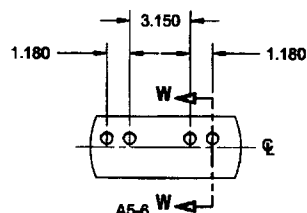


MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

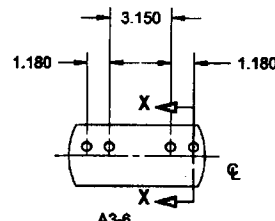
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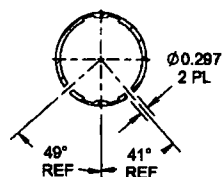
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SCALE 2X



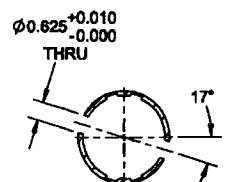
DETAIL T
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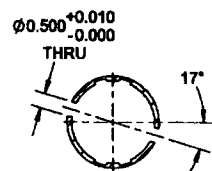
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL

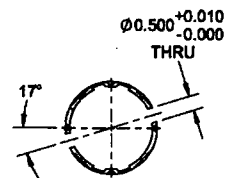
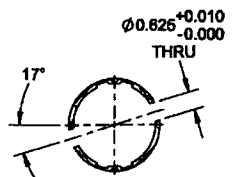
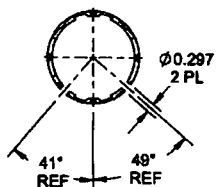
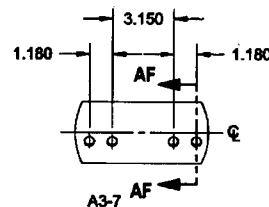
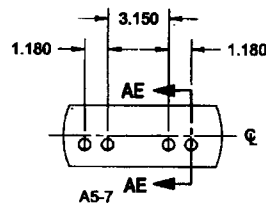
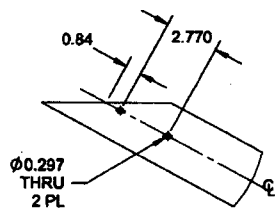
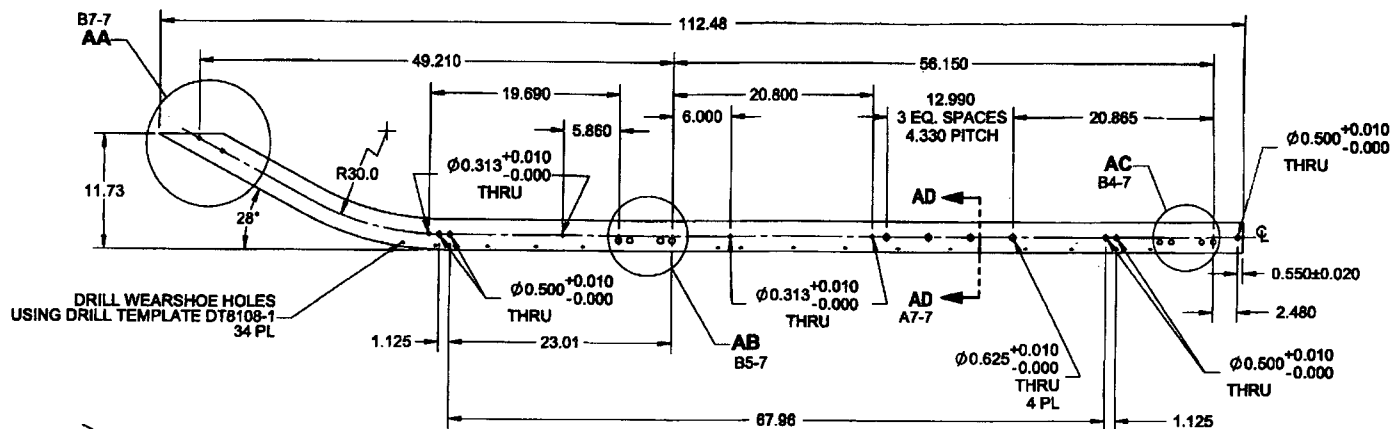


SECTION X-X
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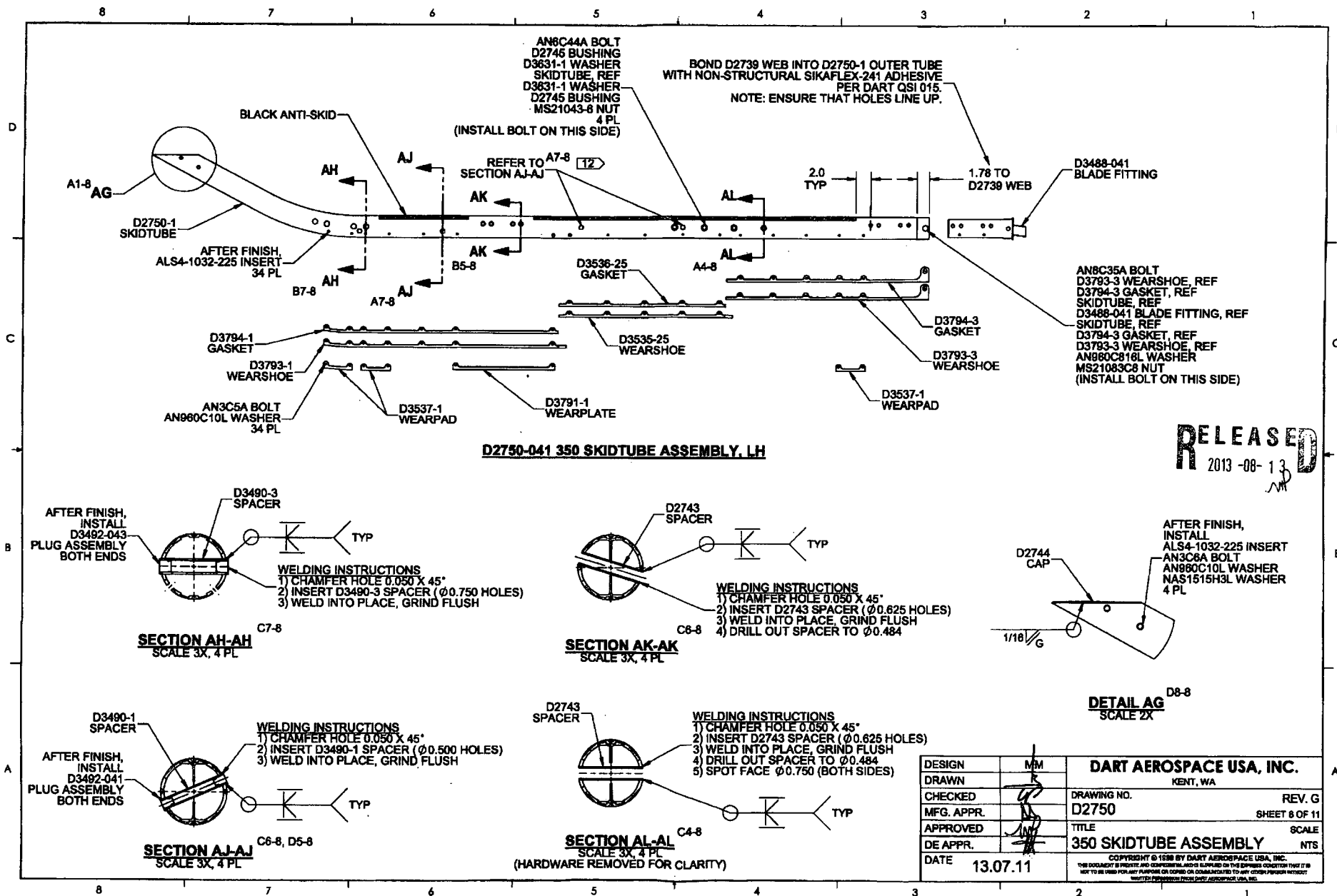
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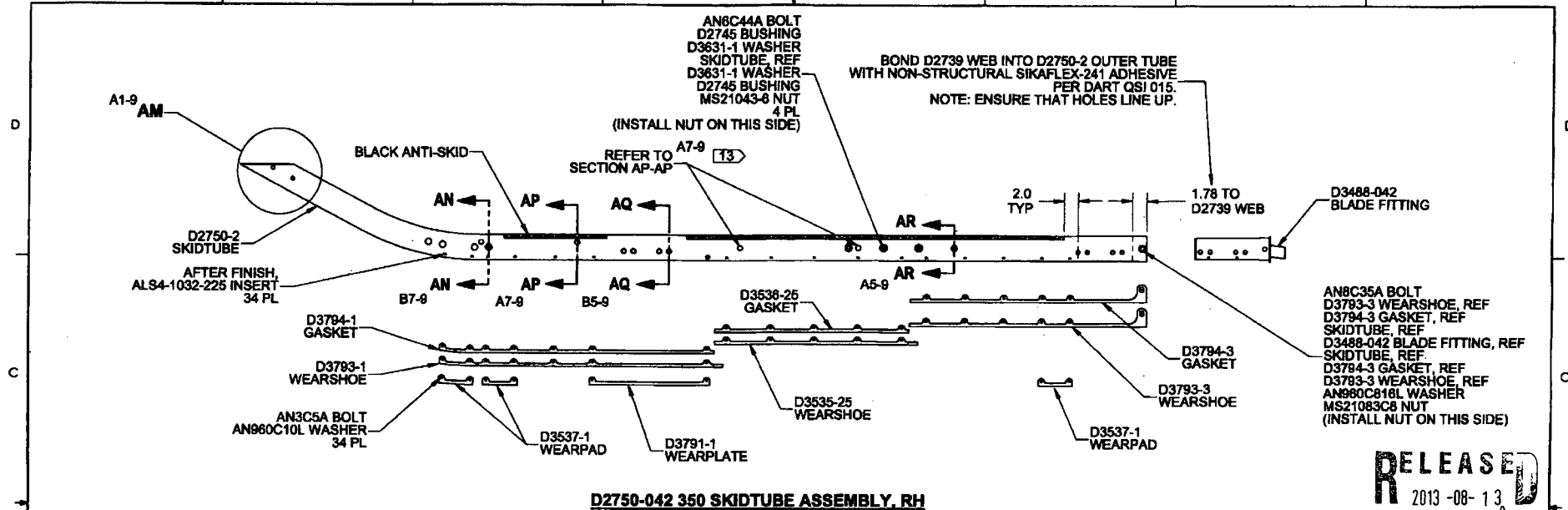


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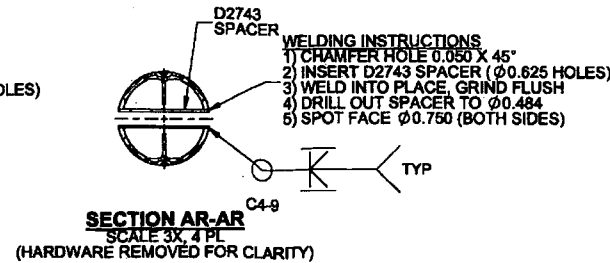
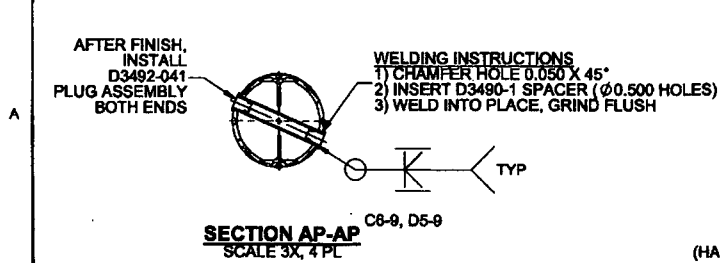
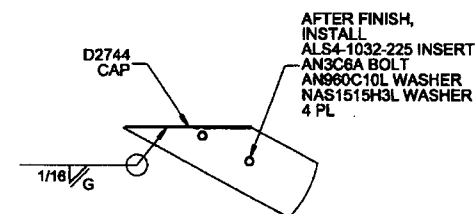
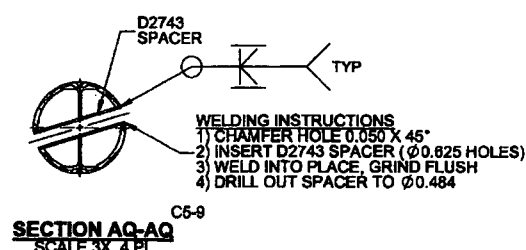
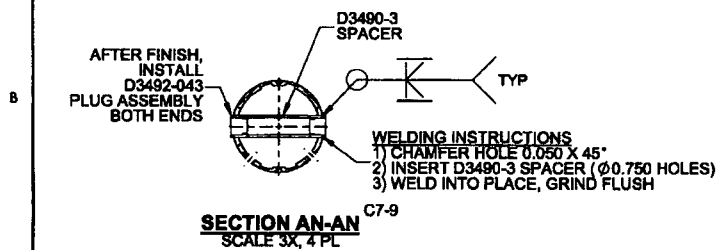
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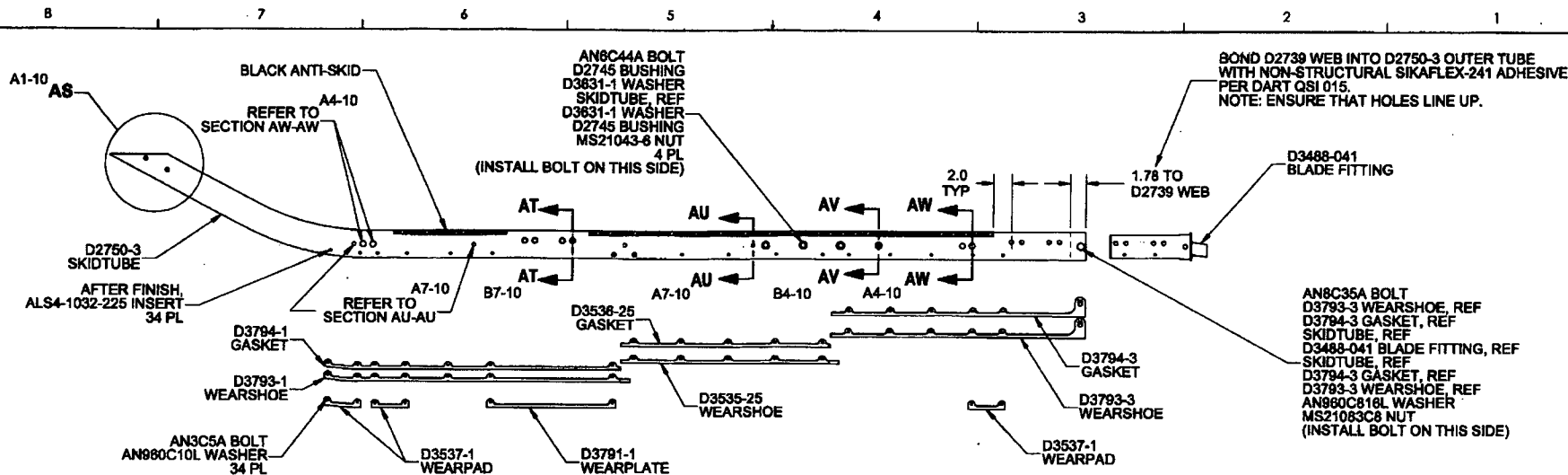


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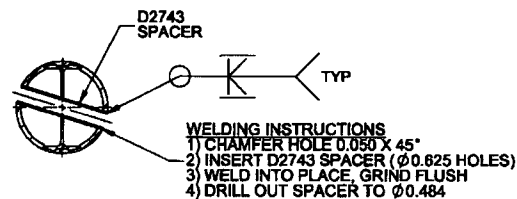


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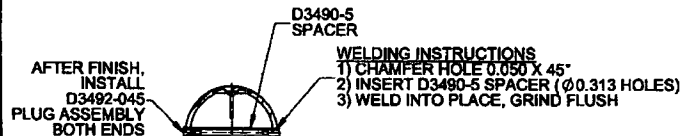
D2750-043 350 SKIDTUBE ASSEMBLY, LH



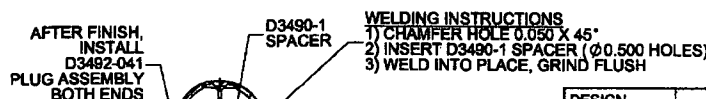
SECTION AT-AT
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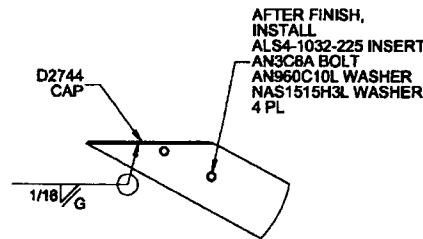
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SECTION AU-AU
SCALE 3X, 4 PL



SECTION AW-AW
SCALE 3X, 4 PL

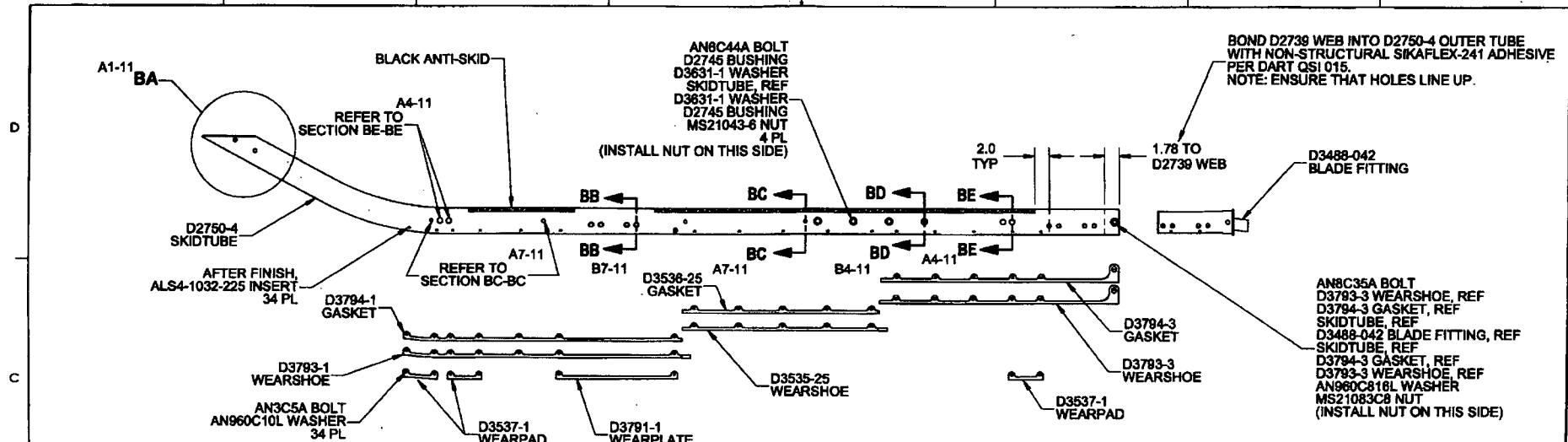


DETAIL AS
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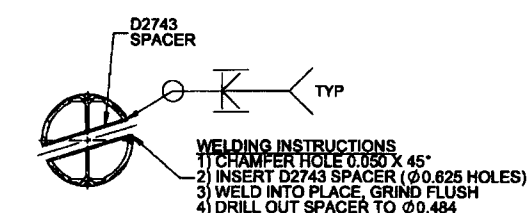
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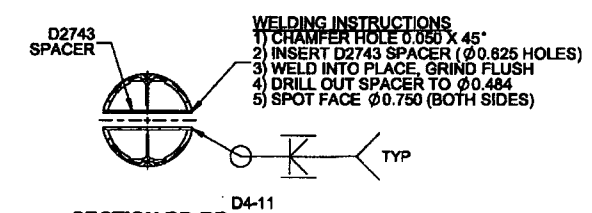
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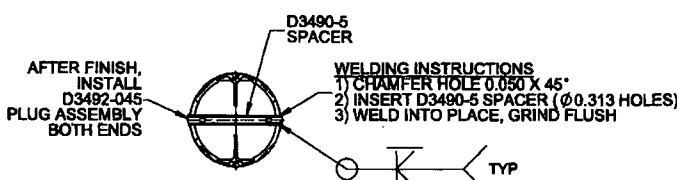
D2750-044 350 SKIDTUBE ASSEMBLY, RH



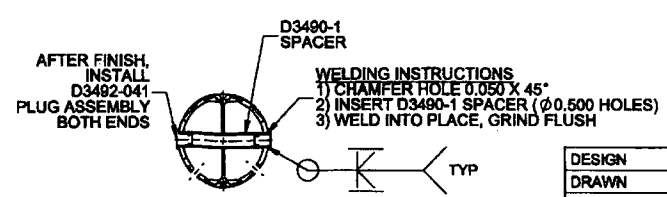
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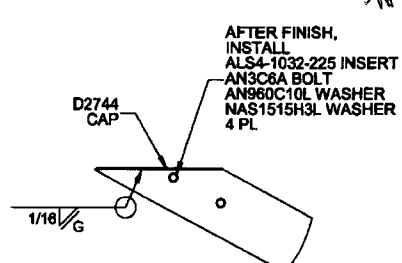
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

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